



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-567-115
Job Sheet 170919



Part No: D350-567-115

Job Qty: 3 ea

Part Name: Replacement Interior Window



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/24/18

Job Tracking No:

Due Date: 2/13/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG DSI9745-011 REV A, IIN-D350-567 REV E SHEET 28 IPP Rev:A New Issue 04-08-24 JLM IPP Rev:B
CHG#2 ECN 1055 07-11-21 DD verified by:EC IPP Rev:C 08-10-07 as per revD DD verified by: IPP REV:D
13.10.15 AS PER IIN REV.E DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	3 Ea		2/13/18	0.00	0.00	Start Up Stores/Pkg-2			FEB 9 7 2018
110	Packaging	3 pcs		2/13/18	0.00	0.00	Packaging1-3			FEB 26 2018
120	QC	3 pcs		2/13/18	0.00	0.00	QC4			58
125	DC	3 pcs		2/13/18	0.00	0.00	DC			9-89DAS
130	Packaging	3 pcs		2/13/18	0.00	0.00	Packaging3-1			58 27 2018
140	QC21-FG	3 Ea		2/13/18	0.00	0.00	QC21			APR 7 6 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-4A	Bolt	12 Ea (4 ea)	90-Start up Operation	
AN526C632R12	Screw	27 Ea (9 ea)	90-Start up Operation	
D2463 5021101	1/2" Seal (\$ Per Foot) 53" x 3	13.2300 ft (4.41 ea)	90-Start up Operation	
D3293-1	Doubler For Interior Window For -111	3 Ea (1 ea)	90-Start up Operation	
D3294-1	Bracket For Interior Window For -115	3 Ea (1 ea)	90-Start up Operation	
D3295-041	Replacement Interior Window For -111	3 Ea (1 ea)	90-Start up Operation	
D3296-041	Replacement Interior Door For -111	3 Ea (1 ea)	90-Start up Operation	
D5420-1	Doubler Plate	3 Ea (1 ea)	90-Start up Operation	
DT8439	Template	3 (1 ea)	90-Start up Operation	
MS20426AD3-5	Rivet	24 Ea (8 ea)	90-Start up Operation	
MS20470AD4-5	Rivet, Universal Head	6 Ea (2 ea)	90-Start up Operation	
MS20470AD4-6	Rivet, Universal Head	345 Ea (115 ea)	90-Start up Operation	
MS20470AD4-7	Rivet, Universal Head	45 Ea (15 ea)	90-Start up Operation	
MS21042L06	Nut	27 Ea (9 ea)	90-Start up Operation	
MS21062L3	Nut Plate	12 Ea (4 ea)	90-Start up Operation	
NAS1149DN632J	Washer	27 pcs (9 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-4A	12	437	0
	AN526C632R12	27	248	0
	D2463 - OS Bruce	13	498	0
	D3293-1	3	2	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

Date : _____



Replacement Interior Window

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DEPARTMENT/PROCESS

☐ Water Jet	☐ Engineering
☐ Prod. Eng. Coord.	☐ Quality
☐ Rec/Store/Packaging	☐ Other
☐ Supplier	

MRB (QSI042) Approval

in

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

PART NO: D350-567-115
Original Serial #: S038419
Revision:
Operation: Start up Operation
Change No: CHG005

02/02/18

Job No: 170919

Root Cause

☐ Environment	☐ No Re-verification
☐ Design	☐ Operator
☐ Doc/Data	☐ Offset/Setup
☐ Equip/Tooling	☐ Supplier
☐ Handling/Pre	☐ Training
☐ Material	☐ Use for Testing
☐ Internal Transport	☐ Poor Information
☐ Tribal Knowledge	☐ Rushing
☐ LOA	☐ Product Improvement
☐ Substation	☐ Process Improvement
☐ Past Expiry Date	☐ Manufacturing Process
☐ Misidentified	☐ Past Due

FAULT CATEGORY

☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish
☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence

OTHER :

D3294-1	3	2	0
D3295-041	3	2	0
D3296-041	3	1	0
D5420-1	3	6	0
DT8439	3	0	0
MS20426AD3-5	24	8,510	0
MS20470AD4-5	6	2,532	0
MS20470AD4-6	345	884	0
MS20470AD4-7	45	1,349	0
MS21042L06	27	264	0
MS21062L3	12	27	0
NAS1149DN632J	27	491	0

Part Specifications

Specifications could not be found.

Plex 1/24/18 9:59 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Master Unit 000410

Tel (613) 632-5200

Containers on Master Unit 000410				
Serial No	Part No	Customer Part No	Status	Quantity
✓ S038349	AN3-4A		Allocated	12
✓ S038347	AN526C632R12		Allocated	27
✓ S038345	D2463	D2463	Allocated	13.23
✓ S038332	D5420-1		Allocated	3
✓ S038327	MS20426AD3-5		Allocated	24
✓ S038324	MS20470AD4-5		Allocated	6
✓ S038320	MS20470AD4-6	MS20470AD4-6	Allocated	345
✓ S038316	MS20470AD4-7		Allocated	45
✓ S038313	MS21042L06	MS21042L06	Allocated	27
✓ S038310	MS21062L3		Allocated	12
✓ S038309	NAS1149DN632J		Allocated	27

D3294-1 S03951x11 ~~165510~~ ✓ F163699x1
 D3293-1 S013989x2 (1x) S044197
 ✓ D3295-041 F167272 (x1) S044198 (v2)
 D3296-041 163333x1 ~~163333~~ x1
 D3296-041 - S042807 _____ x1

5.0 PARTS LIST

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		1			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1			D2463-0860	NEOPRENE SEAL
	9	12			2600-6	¼ TURN FASTENER
	9	12			2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21			AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ. YD	2 SQ. YD	2 SQ. YD			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
				1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
				1	D3213-041	DOOR ASSEMBLY
			1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
			1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
			9	8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
			9	8	AN960JD6	WASHER
			9	8	MS21042L06	NUT (OR MS21042-06)
			2	40	MS20470AD4-5	RIVET
			115	90	MS20470AD4-6	RIVET
			15	20	MS20470AD4-7	RIVET

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Revision: E

Date: 13.08.15

EDIT 5.0/25.7 PARTS LIST:**REFERENCE ONLY**

For customers with kits D350-567-013/-015/-017/-023/-025/-027/-117 @ CHG002 and earlier,
Customers with kits D350-567-111 @ CHG006 and earlier,
Customers with kits D350-567-115 @ CHG004 and earlier,
Customers with kits D350-567-031/-031B/-111B/-115B @ CHG001 and earlier,
Procure kit DSI 9745-011

Item	Qty	Part Number	Description
	X	DSI 9745-011	FIRE EXTINGUISHER RELOCATION KIT
1	1	D5420-1	DOUBLER PLATE
2	4	AN3-4A	HEX HEAD BOLT
3	8	MS20426AD3-5	CSK RIVET
4	4	MS21062L3	NUTPLATE

For customers with kits D350-567-013/-015/-017/-023/-025/-117 @ CHG003 and later,
Customers with kits D350-567-111 @ CHG007 and later,
Customers with kits D350-567-115 @ CHG005 and later,
Customers with kits D350-567-031/-031B/-111B/-115B @ CHG002 and later,
Refer to Installation Instructions D350-567 and ICA-D350-567 and update the parts list as follows:

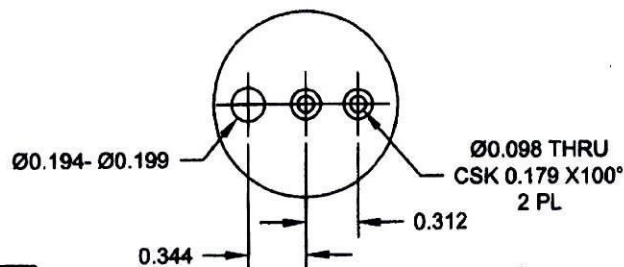
EDIT 5.0 ADD:

Qty	Qty	Qty	Qty	Qty	Part Number	Description
-013	-023	-113	-115	-031		
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATIBLE)
			1	1	D5420-1	DOUBLER PLATE
			4	4	AN3-4A	HEX HEAD BOLT
			8	8	MS20426AD3-5	CSK RIVET
			4	4	MS21062L3	NUTPLATE

EDIT 4.0/25.5 WEIGHT AND BALANCE:

*Note: Does not include fire extinguisher weight

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
DSI 9745-011 (Primary Location)	0.1 lb	+1.6 in	+16 in lb	72.2 in	7.2 in lb
Fire Extinguisher Relocation Kit	0.05 kg	+0.04 m	+0.02 m kg	1.83 m	0.1 m kg
DSI 9745-011 (Alternate location)	0.1 lb	-4.4 in	-44 in lb	65.4 in	6.5 in lb
Fire Extinguisher Relocation Kit	0.05 kg	-0.11 m	-0.01 m kg	1.66 m	0.1 m kg

**DETAIL A**

(NUT PLATE HOLE PATTERN)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 16.04.06
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9745	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ALTERNATE FIRE EX LOCATION	NTS
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